

MAY 28 2018



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D076-612-015
Job Sheet 178066



Part No: D076-612-015

Job Qty: 2 ea

Part Name: S-76 Cargo Mirror Installation, 8" (fits LH or RH)

JUN 04 2018



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/26/18

Job Tracking No:

Due Date: 7/5/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B SHEET 7 IPP Rev:A 05.05.12 New issue KJ/JLM IPP Rev:B 10.09.08 as per ecn 10-607 DD
verf:EC IPP REV:C 14.11.03 ECN14-648/ IIN REVB DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	7/5/18	7/5/18	0.00	0.00	Start Up Stores/Pkg-1		JUN 01 2018
110	Packaging	2 pcs	7/5/18	7/5/18	0.00	0.00	Packaging1-1	DAS 6	JUN 12 2018
120	QC	2 pcs	7/5/18	7/5/18	0.00	0.00	QC4	9-89	JRB
125	DC	2 pcs	7/5/18	7/5/18	0.00	0.00	DC		JRB
130	Packaging	2 pcs	7/5/18	7/5/18	0.00	0.00	Packaging3-1		DAS 21
140	QC21-FG	2 Ea	7/5/18	7/5/18	0.00	0.00	QC21	9-89	18-06-19

Part Op 125 - Photocopy bluefile and create labels per PPP D076-612-015 CHG004

Descriptions: 130 - Identify and pack for shipping as per PPP D076-612-015 Location: _____ PPP Rev: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C10A	Bolt	2 Ea (1 ea)	90-Start up Operation	5019323
AN3C11A	Bolt	6 Ea (3 ea)	90-Start up Operation	FM132035-70
AN4C5A	Bolt	2 Ea (1 ea)	90-Start up Operation	5019407
AN4C6A	Bolt	2 Ea (1 ea)	90-Start up Operation	5027515
CR3553-4-02	Rivet	18 Ea (9 ea)	90-Start up Operation	FM130401
D2012-117	S-76 Clevis	6 Ea (3 ea)	90-Start up Operation	7144390
D2261-041	S-76 Long Arm Assembly	2 Ea (1 ea)	90-Start up Operation	7132939
D2262-041	S-76 Short Arm Assembly	2 Ea (1 ea)	90-Start up Operation	7132940
D2263-1	Clamp	4 Ea (2 ea)	90-Start up Operation	7124606
D2263-3	Clamp	4 Ea (2 ea)	90-Start up Operation	7124607
D2264	S-76 Cushion	6 pcs (3 ea)	90-Start up Operation	50276032
D2271-041	S-76 L Bracket Assembly	6 Ea (3 ea)	90-Start up Operation	7123828X1
D3439-101	Mirror Assembly 8"	2 Ea (1 ea)	90-Start up Operation	7163236
D5077-1	Spacer	4 Ea (2 ea)	90-Start up Operation	7132941
D5081-1	S-76 Radius Block	4 Ea (2 ea)	90-Start up Operation	7124598
MS21043-3	Nut	12 Ea (6 ea)	90-Start up Operation	5034415
MS21043-4	Nut	6 Ea (3 ea)	90-Start up Operation	5056040
MS27039C1-14	Screw	6 Ea (3 ea)	90-Start up Operation	FM129406
NAS1149C0363R	Washer	12 Ea (6 ea)	90-Start up Operation	5017102
NAS1149C0463R	Washer	12 Ea (6 ea)	90-Start up Operation	5019381

Job Allocations

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			Approval Verification		
			C / QA Coordinator Approval		
Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	 Container No: S080441 Part: D076-612-015 Job No: 178066 Serial No/Batch: S080441 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 06/12/18	
Design ☐	Operator ☐	Bending ☐	Set-up ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C10A	2	26	0
	AN3C11A	6	42	0
	AN4C5A	2	99	0
	AN4C6A	2	375	0
	CR3553-4-02	18	20	0
	D2012-117	6	40	0
	D2261-041	2	2	0
	D2262-041	2	2	0
	D2263-1	4	24	0
	D2263-3	4	133	0
	D2264	6	0	0
	D2271-041	6	1	0
	D3439-101	2	22	0
	D5077-1	4	32	0
	D5081-1	4	9	0
	MS21043-3	12	1,075	0
	MS21043-4	6	916	0
	MS27039C1-14	6	53	0
	NAS1149C0363R	12	363	0
	NAS1149C0463R	12	251	0
Part Specifications				
Specifications could not be found.				

Plex 5/28/18 7:16 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
003621	S077490	AN3C10A	Bolt	S019323	ST349	2
003621	S077480	AN3C11A	Bolt	FM132035-70	ST349	6
003621	S077479	AN4C5A	Bolt	s019407	ST345	2
003621	S077478	AN4C6A	Bolt	S027515	ST345	2
003621	S077458	CR3553-4-02	Rivet	fm130401	ST317	18
003621	S077471	D2012-117	S-76 Clevis	F144390	WA004	6
003621	F132939	D2261-041	S-76 Long Arm Assembly		ST368	2
003621	F132940	D2262-041	S-76 Short Arm Assembly		ST352	2
003621	S077454	D2263-1	Clamp	f124606	ST005	4
003621	S077455	D2263-3	Clamp	f124607	ST005	4
003621	S077470	D2264	S-76 Cushion	S076632	ST005	6
003621	F123828	D2271-041	S-76 L Bracket Assembly		ST006	1
003621	S080440	D2271-041	S-76 L Bracket Assembly	s080123	ST006	5
003621	F163236	D3439-101	Mirror Assembly 8"		ST383	2
003621	S077453	D5077-1	Spacer	F132941	ST137	4
003621	S077452	D5081-1	S-76 Radius Block	f124598	ST138	4
003621	S077451	MS21043-3	Nut	S034415	ST302	12
003621	S077450	MS21043-4	Nut	S056040	ST302	6
003621	FM129406	MS27039C1-14	Screw		ST277	6
003621	S077449	NAS1149C0363R	Washer	s017102	ST266	12
003621	S077448	NAS1149C0463R	Washer	s019381	ST266	12

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 6/12/18 2:08 PM dart.quirion.sonia

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D076-612-011 Cargo Mirror, 6"	1.8 lb 0.82 kg	±46.5 in ±1.18 m	±83.7 in-lb ±0.97 m-kg	99.1 in 2.52 m	178.4 in-lb 2.07 m-kg
D076-612-015 Cargo Mirror, 8"	2.3 lb 1.04 kg	±46.5 in ±1.18 m	±107.0 in-lb ±1.23 m-kg	99.1 in 2.52 m	227.9 in-lb 2.62 m-kg

5.0 PARTS LIST

Qty -011	Qty -015	Part Number	Description
X		D076-612-011	CARGO MIRROR, 6"
	X	D076-612-015	CARGO MIRROR, 8"
1		D2011-101	Mirror (6")
	1	D3439-101	Mirror (8")
3	3	D2012-117	Clevis
1	1	D2261-041	Long Arm Assembly
1	1	D2262-041	Short Arm Assembly
4	2	D2263-1	Clamp
	2	D2263-3	Clamp
3	3	D2264	Cushion
3	3	D2271-041	L Bracket Assy
2	2	D5077-1	Spacer
2	2	D5081-1	Radius Block
1	1	AN3C-10A	Bolt
3	3	AN3C-11A	Bolt
1	1	AN4C-5A	Bolt
1	1	AN4C-6A	Bolt
6	6	NAS1149C0363R	Washer
6	6	NAS1149C0463R	Washer
6	6	MS21043-3	Nut
3	3	MS21043-4	Nut
3	3	MS27039C1-14	Screw
9	9	CR3553-4-02	Blind Rivet

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REFERENCE ONLY

Revision: B
Date: 14.02.13

Change Record

PAGE 1 OF 1

Part Number: D076-612-015

Description: CARGO MIRROR, 8"

[illegible]